

July 05

Work Order ID 71039

Tuesday, June 21, 2011 1:13:13 PM



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 6/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/1/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date: *7/06/21*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3414	Rev C

100



Waterjet

Memo

0.00

B11-6-27

FLOW CNC Waterjet

304 - 100

1-Cut as per Dwg D3414-1

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B116-57

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

120



QC8- Inspect parts - second check

QC

Quality Control

130



Brake NC

Brake NC

Memo

1-Deburr

2-Form using DT8254 as per Dwg D3414

140



Large Fab

Large Fab

Memo

1- Weld using location Jig DT9625 as per Dwg D3414
A/R S.S. welding rod Batch: M117659Set Up/
Run Hours

0.00

SW04127

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

0.00

0.00

SB 1166128

113

0.00

0.00

B

B 11-2-19

113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 71039

Tuesday, June 21, 2011 1:13:14 PM



Page 3

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Start Date: 6/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/1/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

6/11-07-20

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

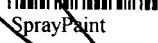
0.00

Sulat/20

(43)

Memo

0.00



SprayPaint

Spray Painting

(172) Janderson
White per DST005
Memo
PRIME B
DELFLEET BLUE B
DELFLEET CLEAR B
10:15
4000
7115

0.00

0.00

13 Bil 11-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, June 21, 2011 1:13:14 PM



Page 4

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Item Name: Lug Assembly

Stop



Start Date: 6/21/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/1/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

185



QC

Quality Control

Operation
Description

QC1- Inspect Spray Paint

DC3

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: 477

0.00

Memo

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF

11-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:13:36 PM

Page 1

Work Order ID: 71039



Parent Item: D3414-041



Parent Item Name: Lug Assembly

Start Date: 6/21/2011

Required Date: 7/1/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA 		Purchased	No			100	sf	148.8000	0.155	1.24		B 11-6-07	

304/316 0.100" Sheet

Location Loc Qty Loc Code

MAT019 148.8
113062 118.3
113077 30.5

D3414-3



Manufactured No

Lug

Location Loc Qty Loc Code

WA 21
69882 21

113077

(B)

EZ 11-7-19.

Location Loc Qty Loc Code

WA 21
69882 21

10412

X13

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71039
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-6-27	Date:	11/06/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	 

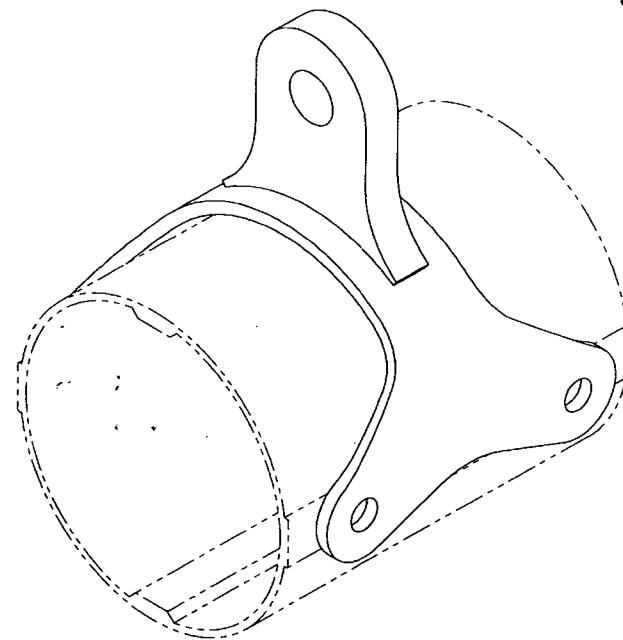
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NOTE: Date & initial all entries

ITEM No.	QTY. 041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71039

PL 11-06-21

RELEASED
01/06/2014

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND DRAWN IN REFERENCED "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR108). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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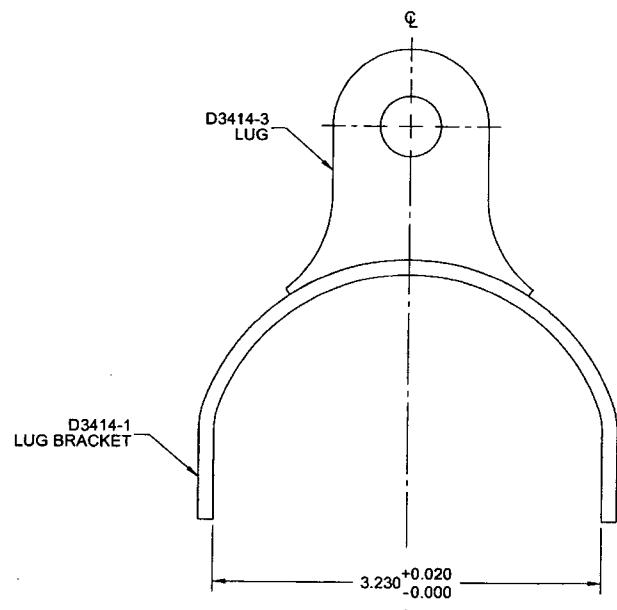
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

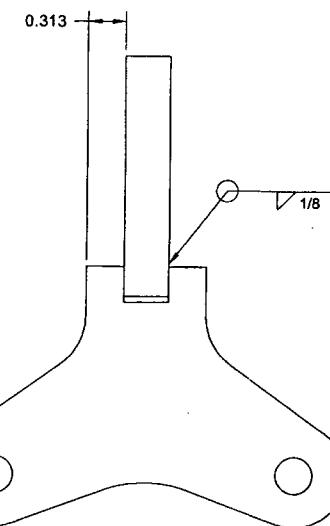
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D3414-041 LUG ASSEMBLY

3 2 1

WB 11039



RELEASED
04/16/14

A

A

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. C	
MFG. APPR.	ED	DRAWING NO.	D3414
APPROVED	MP	TITLE	SHEET 2 OF 3
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8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries

8

7

6

5

4

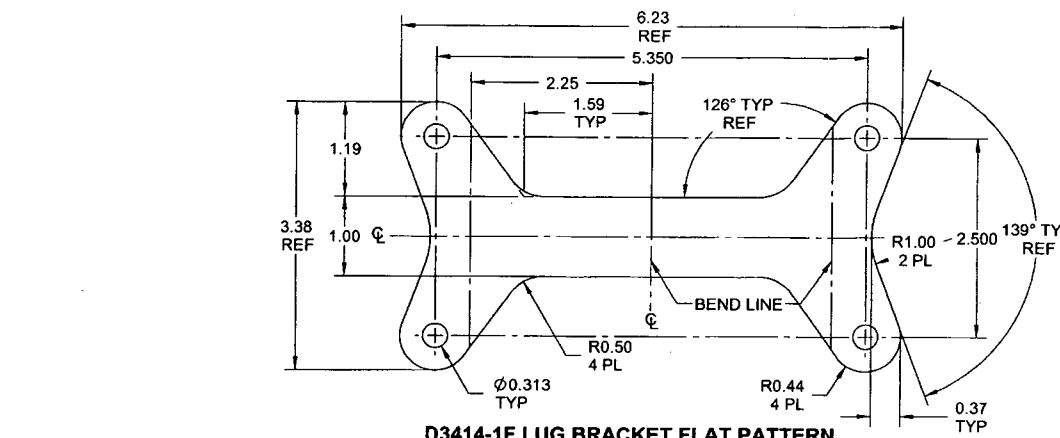
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2

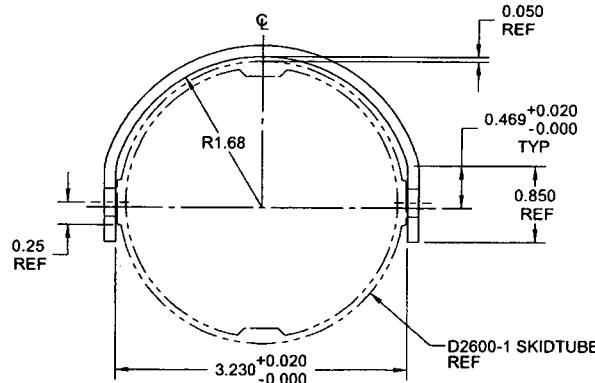
1

D

D



D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

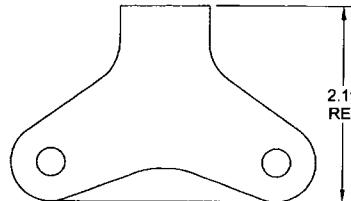
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

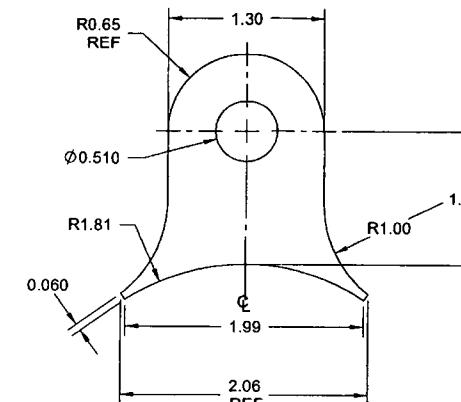
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG

RELEASED
[Signature]

DESIGN	OP	DART AEROSPACE LTD
DRAWN	OP	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. C
APPROVED		TITLE
DE APPR.		SCALE
DATE	09.06.17	NTS

D3414

LUG ASSEMBLY

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